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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2896-1
Job Sheet 191143

Part No: D2896-1		Job Qty: 12 pcs	
Part Name: Support			
Part Weight: 0 lbs		Status: New	Priority: Medium
Job Created: 2/21/19		Job Tracking No:	
Due Date: 3/22/19		Created By: Jesse White	
Type: Stock		Description:	
Note: DWG REV C IPP: B 02.11.26 Reformat; Added P/O; Added mask hole KJ IPP Rev:C As per Rev B 07-04-16 JLM IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC			
Ship Via:			

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	3/22/19	0.32	39.74	HAAS - 1			
						HAAS - 2			
						HAAS - 3			
						HAAS - 4			
120	QC 8	12 pcs	3/22/19	0.00	0.00	QC 8 - 12		KJ 19-05-09	
						QC 8 - 14			
						QC 8 - 17			
						QC 8 - 20			
						QC 8 - 25		Amal 14/05/19	
						QC 8 - 3			
						QC 8 - 32			
						QC 8 - 33			
						QC 8 - 35			
						QC 8 - 39			
						QC 8 - 4			
						QC 8 - 44			
						QC 8 - 45			
						QC 8 - 49			
						QC 8 - 58			
						QC 8 - 8			
						QC 8 - 9			
						QC 8 - 68			
						QC 8 - 67			
						QC 8 - 47			
130	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	0.00	0.00	Packaging 3 - 1 - B4B			
						Packaging 3 - 2 - B4B			
						Packaging 3 - 3 - B4B			
						Packaging 3 - 4 - B4B			
						Packaging 3 - 5 - B4B			
						Packaging 3 - 6 - B4B			

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CANADA
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Container No: S176491



Part: D2896-1
Job No: 191143
Serial No/Batch: S176491
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 04/30/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	AR 19-5-9
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
140 QC 21 - SA	12 pcs	3/22/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-88

Part Op 100 - (HAAS CNC Vertical Machine) Machine as per Folio FA167 Folio Rev: 49 Deburrr ****Program Match MAY 09 2019

Descriptions: #*****

120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location:) LOCATION : LG053

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
DSK080	D2896-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	5169569

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK080	6	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	2.152Inches	+ 0.020 - 0.000	2.172 2.152	
2	Support	2.340Inches	+ 0.020 - 0.000	2.360 2.340	
3	Support	3.550Inches	+ 0.010 - 0.000	3.560 3.550	
4	Support	3.770Inches	+ 0.020 - 0.000	3.790 3.770	
5	Support	0.065Inches	+ 0.020 - 0.000	0.085 0.065	
6	Support	0.315Inches	+ 0.020 - 0.000	0.335 0.315	
7	Support	1.420Inches	+ 0.060 - 0.000	1.480 1.420	
8	Support	0.833Inches	+ 0.020 - 0.000	0.853 0.833	
9	Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
10	Support	0.261Inches	+ 0.005 - 0.000	0.266 0.261	
11	Support	0.189Inches	+ 0.005 - 0.000	0.194 0.189	
12	Support	1.970Inches	+ 0.060 - 0.000	2.030 1.970	
13	Support	0.625Inches	+ 0.005 - 0.000	0.630 0.625	
14	Support	101.750Inches	+ 4.000 - 0.000	105.750 101.750	
15	Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053	
16	Support	0.926Inches	+ 0.020 - 0.000	0.946 0.926	

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DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.355	2.350	2.350	2.350	2.355
AC	3.550	3.560		3.553	3.554	3.559	3.559	3.557
AD	3.770	3.790		3.771	3.772	3.776	3.776	3.775
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325
AF	1.42	1.48		1.446	1.446	1.448	1.446	1.446
AG	0.833	0.853		0.842	0.842	0.840	0.841	0.840
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.189	0.189	0.189	0.189	0.189
AK	1.970	2.030		2.000	2.000	2.000	2.000	2.000
AL	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.939	0.939	0.940	0.940	0.940
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject								

Measured by: <i>KJ</i>	Date: <i>2019-04-30</i>
Audited by: <i>mmL</i>	Date: <i>19/05/08</i>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	X6	X7	X8	X9	X10
HAAS Section								
AA	2.152	2.172		2.163	2.163	2.163	2.163	2.163
AB	2.340	2.360		2.355	2.355	2.355	2.355	2.354
AC	3.550	3.560		3.550	3.551	3.556	3.555	3.554
AD	3.770	3.790		3.776	3.775	3.776	3.774	3.774
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.315	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325
AF	1.42	1.48		1.446	1.446	1.446	1.443	1.444
AG	0.833	0.853		0.840	0.840	0.840	0.840	0.840
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AJ	0.189	0.194		0.188	0.189	0.188	0.188	0.188
AK	1.970	2.030		2.000	2.000	2.000	1.998	1.998
AL	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.940	0.940	0.940	0.937	0.937
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject								

Measured by: KJ	Date: 2019-05-01
Audited by: JMM	Date: 17/05/08
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
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HAAS Section								
AA	2.152	2.172		2.163	2.163			
AB	2.340	2.360		2.350	2.350			
AC	3.550	3.560		3.556	3.555			
AD	3.770	3.790		3.775	3.774			
AE	0.085 x 0.315	0.085 x 0.335		.075 x .285	.075 x .325			
AF	1.42	1.48		1.444	1.443			
AG	0.833	0.853		.840	.840			
AH	0.240	0.260		R.250 ok	R.250 ok			
AI	0.261	0.266		.261φ	.261φ			
AJ	0.189	0.194		.188φ	.188φ			
AK	1.970	2.030		1.998	1.998			
AL	0.625	0.630		.625	.625			
AM	101.75	105.75		102.75°	103.75°			
AN	0.053	0.073		R.063 ok	R.063 ok			
AO	0.926	0.946		.936	.937			
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject								

Measured by:	DAS 64 9-89	Date:	20/05/02
Audited by:	am hml	Date:	19/05/08
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
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